

(19)



Eur päisches Patentamt
European Patent Office
Office européen des brevets

(11) Publication number:

0 185 169
A2

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: 85113548.3

(51) Int. Cl.⁴: E 04 D 5/10
D 06 N 5/00, B 32 B 5/08

(22) Date of filing: 24.10.85

FGEL
FNLA
FNLC

E
276 UNTE
UN30

Defess ✓

(30) Priority: 20.12.84 US 684116

(43) Date of publication of application:
25.06.86 Bulletin 86/26

(84) Designated Contracting States:
AT BE CH DE FR GB IT LI NL SE

(71) Applicant: Bay Mills Limited
39 Seapark Drive
St. Catharines Ontario(CA)

(72) Inventor: O'Connor, Terry J.
67 Mill Bridge Crescent
Fonthill Ontario(CA)

(72) Inventor: Cooper, Ian G.
68 Jefferson Drive
St. Catharines Ontario(CA)

(74) Representative: Schmidt-Evers, Jürgen, Dipl.-Ing. et al,
Patentanwälte Dipl.-Ing. H. Mitscherlich Dipl.-Ing. K.
Gunschmann Dipl.-Ing. Dr.rer.nat. W. Körber Dipl.-Ing. J.
Schmidt-Evers Dipl.-Ing. W. Melzer Steinsdorfstrasse 10
D-8000 München 22(DE)

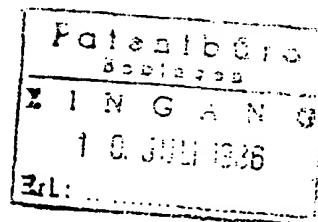
4 Az 10.1.86

(54) Reinforcing composite for roofing membranes and process for making such composites.

4 Az 26.04.86

(57) A reinforcing composite for bituminous roofing membranes is made by laminating fiberglass and polyester mats and scrims coated with thermosetting adhesives.

EP 0 185 169 A2



4 4 4 5

October 24, 1985

- 1 -

Reinforcing Composite for
Roofing Membranes and Process
for Making Such Composites

Background of the Invention

1. Field of the Invention

- 1 This invention relates to a composite for use in
reinforcing roofing membranes made from bituminous
materials. The use of this invention by manufacturers of
such membranes results in significantly easier processing
5 with less-complicated equipment. Moreover, sufficient
strength in the roofing membranes can be achieved with
less reinforcing material than previously used. The
membranes may also be made significantly thinner, which is
not only a saving in the amount of bituminous raw material
10 required and a reduction in the weight load on the roof
after installation, but also increases flexibility so that
handling during installation involves a decreased risk of
creating cracks or other weaknesses which could lead to
leaks. Furthermore, by proper selection of materials, the
15 membranes can be made relatively stiff or thick, which is
desirable in some circumstances.

1 2. Description of the Prior Art

Asphalt-like roofing membranes, such as those which are used on flat roofs, have been made from bituminous materials reinforced with three separate layers of reinforcing materials: polyester mat, non-woven fiberglass scrim, and fiberglass mat. Other combinations of separate layers used previously have included (a) polyester mat and fiberglass scrim, (b) fiberglass mat and polyester scrim, and (c) polyester mat and fiberglass scrim. These reinforcing layers have been unwound from their respective separate rolls and led together through a tank or vat of heated bituminous material using methods which are known in the art. We are using "mat" in its usual meaning of an entangled mass of filaments and "scrim" in its usual meaning of an open fabric. The bituminous material has been a "modified bitumen" such as asphalt combined with about 20% by weight of atactic polypropylene or 5 to 15% styrene butadiene styrene rubber. The bituminous material has acted as an adhesive to hold the layers within the membrane. It has also been described that a single reinforcing composite may be prepared of at least one layer of fiberglass, at least one layer of polyester, and at least a third layer which is fiberglass or polyester. Furthermore, these materials may be formed such that at least one of them is in the form of a mat, at least one is in the form of a scrim coated with a thermoplastic adhesive, and at least a third layer is in the form of a mat or a scrim. In addition, as set forth below, we have learned that it is possible to make a composite with advantageous properties for some uses which does not require a scrim with a thermoplastic adhesive.

Summary of the Invention

35 Our invention provides making the single reinforcing composite comprising three or more layers bonded together

1 with a thermosetting resin adhesive. The words
"thermosetting adhesive" are used herein to mean a
thermosetting adhesive which maintains its bonding ability
and stiffness up to about 425°F, that is to say, a
5 thermosetting adhesive which is not tacky and soft at
about 425°F. In accordance with this definition, it will
be understood that some thermosetting adhesives, if
partially cured, may act as thermoplastic adhesives.

10 These layers may be bonded together by the adhesive under
heat to form a single, thin composite which is useful for
reinforcing roofing membranes. In a preferred embodiment,
they may be bound together using a thermosetting adhesive,
which may be applied to a scrim layer and then laminating
15 the other layers to that scrim layer before the adhesive
has completely set to form a single composite which is
useful for reinforcing roofing membranes.

Our process and the composite made from it have several
20 advantages over the prior art, including the following.
By combining the various reinforcing elements as we
describe, the thickness and weight of each layer can be
reduced because each one need not be self-supporting when
it is subjected to stress at the time it is unwound and
25 bituminous material is applied. Moreover, the composites
of this invention may have a reduced total thickness for
the reinforcing layer, which results in less bituminous
material being required. This reduction in material not
only cuts costs, but increases ease of handling and
30 reduces roof-loads when installed. The thinner
reinforcing membrane and the resulting reduction in
overall thickness also gives additional significant
advantages beyond reduction in materials and weight. A
thinner roofing membrane is less likely to crack or
35 develop weaknesses during installation, which could lead
to leaks when it is made into rolls and stored,

1 transported, unrolled, and applied to roofs. This is
particularly important in winter in colder climates. A
single reinforcing element also results in easier
processing for the manufacturer, who need not be concerned
5 with aligning separate reinforcing elements while they are
led to and through the vats of hot bituminous material.

When a thermosetting adhesive is used to bind the
composite into one layer, the composite has the advantage
10 of being adaptable to a wider variety of processing
conditions and equipment than when a thermoplastic resin
acts as the binder. In addition, with thermosetting
resins it is possible to make thicker and/or stiffer
composites, which is desirable in some uses for roofing
15 membranes.

In reinforcing composites of this invention, if two glass
components are used, we prefer to place them side by side.

20 Fiberglass has advantageous properties of tensile
strength, thermal dimensional stability, and resistance to
wear and deterioration such as may be due to ultraviolet
light. Polyester mat and scrim provide tear resistance.
The scrims used in this invention may be coated with a
25 thermoplastic adhesive such as polyvinyl chloride ("PVC")
latex adhesive or PVC plastisol adhesive. But if
thermoplastic adhesive is used to bind the non-woven scrim
together, it should be compatible with the thermosetting
resin to be used. The scrim used in this invention is
30 preferably a non-woven scrim or a weft-inserted warp knit
fabric or other knit fabric, through it may also be
woven. We prefer that the fiberglass yarns range from 150
1/0 (15000 yards/pound yield, 330 dtex) to 75 1/0 or
heavier, up to 18 1/0 (1,800 yards/pounds yield, 2,640
35 dtex).

1 The weight of fiberglass scrim (including any
thermoplastic adhesive used to bind it together) we prefer
may range from 0.35 ounces per square yard (12
grams/square meter) to 7 ounces per square yard (235
5 grams/square meter), with weights of about 5 ounces per
square yard being optimal. Thermoplastic adhesives when
used on fiberglass scrim to bind a non-woven scrim
together may range in weight preferably from 3 parts (by
weight) of adhesive to 100 parts (by weight) of yarn up to
10 100 parts of adhesive to 100 parts of yarn.

Polyester scrim (including adhesive) may preferably range
in weight between 0.25 ounces per square yard (8.5 grams
per square meter) and 5 ounces per square yard (including
15 adhesive) made of threads of 200 to 3000 denier (220 to
3300 dtex), with 500 to 2000 denier (550 dtex to 2200
dtex) being preferable and 1000 denier (1100 dtex) threads
being most preferred. The weight of thermoplastic
adhesive when used on polyester scrim to bind non-woven
20 scrim together may range in weight preferably between 20
and 100 parts (by weight) to 100 parts (by weight) of
yarn, with the most preferred range being 25 to 50 parts
of adhesive.

25 The weight of thermosetting adhesive when used as a binder
for the composite may range between 5 and 100 parts (by
weight) to 100 parts (by weight) of yarn, with the
preferred range being 25 to 50 parts of adhesive. When an
adhesive bonded scrim is used, the weight of the adhesive
30 in the scrim is included in the yarn weight for these
calculations.

Examples of suitable thermoplastic adhesives for the
fiberglass and polyester non-woven adhesive bonded scrims
35 are polyvinyl chlorides such as PVC plastisol (PVC
dispersion in plasticizer), and PVC latex, having melting

- 1 temperatures ranging from 275°F (135°C) to 425°F (220°C). Other forms of polymeric resins such as acetates and acrylics may be used, as may other thermoplastic adhesives.
- 5 The preferred thermosetting adhesives to bind the laminated composite together, for both fiberglass and polyester non-woven adhesive bonded scrims are polyvinyl alcohol, styrene butadiene latex, acrylic latex and the water based thermoplastic resins which are capable of
- 10 later modification by the cross linking components of the thermosetting adhesive. Thermosetting adhesives, which are typically a water-based adhesive capable of cross-linking to give a thermoset structure, may also be made by adding thermosetting resins to thermoplastic
- 15 resins (for example, by adding a urea-formaldehyde resin to a styrene-butadiene latex).

The polyester mat may be a paper laid mat of staple filaments or preferably spun bonded of continuous

20 filaments, and preferably having isotropic properties. The weight of the mat per square yard is preferred at 0.4 (14) to 1.0 (34 gm/m²) ounces, though weights up to about 6 ounces per square yard may be used. The fiberglass mat may be formed on a paper machine (by what

25 is known as a wet process), or it may be a resin-bonded (a so-called dry process) staple or continuous filament mat and is preferably isotropic. The fiberglass mat may preferably range in weight from 30 grams to 300 grams per square meter, with 30 to 100 grams being more preferred

30 and 30 to 45 considered optimal.

In the process of laminating using thermosetting adhesive as the laminating adhesive, the scrim fabric or fabrics are unrolled and fed through an adhesive applicator which

35 typically consists of a steel roll resting above a resilient roll, with the lower roll resting in a tray of

1 adhesive. The resin solids of the thermosetting
laminating adhesive, the pressure between the applicator
rolls, and the configuration of the fabric passing through
the rolls may be adjusted by those skilled in the art to
5 obtain the necessary pick up of adhesive onto the fabric.
As the fabric or fabrics leave the adhesive applicator and
travel under tension towards a series of steam-heated
drying rolls, mat components are fed in above and/or below
the scrim fabric or fabrics and all these components then
10 contact one another in traversing a set of at least two
and preferably four or more drying rolls, such that both
sides of the composite receive direct heat to ensure a
good bond on both sides of the structure. The temperature
of the heated rolls, and the running speed may be adjusted
15 by those skilled in the art to obtain thorough drying and
curing in order to obtain maximum adhesion between the
various components.

The composites of this invention are suitable for
20 reinforcing a roofing membrane made, for example, by
running the reinforcing composite through a tank or vat of
hot modified bitumen with thickness controlled by metering
rolls or doctor blades. The finished product is suitable
for application by hot mopping, torching, cold adhesive,
25 or other appropriate methods. It may be fully adhered,
loose laid or mechanically fastened to the roof.

The following examples will illustrate the invention.

30

Example 1

Polyester scrim having 4 x 4 yarns per inch (1.6 x 1.6
yarns/cm) of 1000 denier (1100 dtex) high tenacity
polyester yarn and coated with 20 parts by weight of
35 polyvinyl alcohol resin to give a total weight of 1.25
ounces per square yard (42 grams per square meter) was in

0185169

1 turn coated with an additional 20 parts of cross-linking
acrylic latex and the coated fabric brought into contact
with a fiberglass mat of 1.45 ounces per square yard (50
grams per square meter) on each side of the polyester
5 fabric. The composite was dried and cured.

Example 2

The polyester scrim component mentioned in Example 1,
10 together with a fiberglass scrim having 6 x 6 yarns per
inch (2.4 x 2.4 yarns per cm.) of 370 (1340 dtex) yarn and
coated with 10 parts by weight of polyvinyl alcohol resin
to give a total weight of 2.3 ounces per square yard (77
grams per square meter), were in turn coated with an
15 additional 20 parts of cross-linking acrylic latex and the
coated fabrics brought into contact with a fiberglass mat
of 1.45 ounces per square yard (50 grams per square meter)
on the outer side of the coated fabrics. The composite
was dried and cured.

20

Example 3

Polyester scrim was coated with acrylic adhesive as
described in Example 1 but was laminated with fiberglass
25 mat of 1.45 ounces per square yard (50 grams per square
meter) on one side and a continuous filament spunbonded
polyester mat weighing 2 ounces per square yard (68 grams
per square meter) on the other side. The composite was
dried and cured.

30

Example 4

Polyester scrim and fiberglass scrim were coated with
acrylic adhesive as described in Example 2 but were
35 laminated with a fiberglass mat of 1.45 ounces per square
yard (50 grams per square meter) on one side and a

1 continuous filament spunbonded polyester mat weighing 1
ounce per square yard (32 grams per square meter) on the
other side. The composite was dried and cured.

5 Example 5

Polyester scrim and fiberglass scrim were coated with
acrylic resin as described in Example 2 but were laminated
with a polyester mat of 1 ounce per square yard (32 grams
10 per square meter) on the outsides of the coated fabrics.
The composite was dried and cured.

Example 6

15 Fiberglass scrim having 6 x 6 yards per inch (2.4 x 2.4
yarns per cm.) of 37 1/0 (1340 dtex) yarn and coated with
10 parts by weight of polyvinyl alcohol to give a total
weight of 2.3 ounces per square yard (77 grams per square
meter) was in turn coated with an additional 20 parts of
20 cross-linking acrylic latex and the fabric brought into
contact with a fiberglass mat of 1.45 ounces per square
yard (50 grams per square meter) on one side and a
continuous filament spunbonded polyester mat weighing 2
ounces per square yard (68 grams per square meter) on the
25 other side. The composite was dried and cured.

In each of the above examples the process produced a
reinforcing, impregnatable composite for use in roofing
membranes.

We claim:

- 1 1. A composite for reinforcing roofing membranes
comprising three or more layers bonded together with a
thermosetting resin one of which layers is made of
fiberglass, one of which is made of polyester, and the
5 third of which is made of either polyester or fiberglass;
further, at least one of which is in the form of a scrim,
one of which is in the form of a mat, and a third of which
is in the form of a mat or a scrim; wherein the composite
is flexible, capable of being impregnated by a bitumenous
10 material, and has sufficient strength to be useful in
reinforcing membranes.
2. The composite of claim 1 in which the layers are two
fiberglass mats and a polyester scrim.
- 15 3. The composite of claim 1 in which the layers are two
fiberglass mats, a polyester scrim, and a polyester mat.
4. The composite of claim 1 in which the layers are a
20 polyester mat, a polyester scrim, and a fiberglass mat.
5. The composite of claim 1 in which the layers are a
fiberglass mat, a fiberglass scrim, a polyester scrim and
a polyester mat.
- 30 6. The composite of claim 1 in which the layers are two
polyester mats, a fiberglass scrim, and a polyester mat.
7. The composite of claim 1 in which the layers are a
35 fiberglass mat, a polyester scrim, and a fiberglass scrim.
8. A process for making a composite to use in reinforcing
roofing membranes comprising the steps of;

1 selecting at least three materials, one of which is
 fiberglass, one of which is polyester, and the third of
 which is fiberglass or polyester; one of which is in the
 form of a scrim, one of which is the form of a mat, and
5 the third of which is in the form of either a mat or a
 scrim;

 applying to at least one scrim a coating of
 thermosetting adhesive;

10

 combining the other selected materials with said scrim
 before the adhesive has fully set; and

 thereafter causing the adhesive to set further, thus
15 binding the materials together into a composite; and

 cooling the composite thus created;

 wherein the resulting composite is flexible, capable
20 of being impregnated by bitumenous material, and has
 sufficient strength to be useful in reinforcing roofing
 membranes.

9. The process of claim 8 in which the adhesive is a
25 water-based cross linkable adhesive and the materials
 after being combined are passed over heated rollers which
 cause drying and setting of the adhesive.



European Patent
Office

EUROPEAN SEARCH REPORT

0185169

Application number

EP 85 11 3548

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.4)
Y	EP-A-0 110 039 ✓ (BAY MILLS LTD) * Columns 1,3,6,9-13; page 2, line 26 - page 6, line 10 *	1,5,6,8	E 04 D 5/10 D 06 N 5/00 B 32 B 5/08 B 32 B 11/02
Y	WO-A-8 200 837 --- (VERRETEXTIL) * Columns 1,3,5-7,11,13,15,17; page 1, line 22 - page 6, line 5; figures 1,2 *	1,5,6,8	
A		3,4,7	
A	US-A-4 368 228 --- (R. GORGATI) * Columns 1,5,13,14; column 2, line 58 - column 4, line 20; example 1 *	1,4-6,8	
A	US-A-3 993 828 --- (C.C. MCCORSLEY) * Columns 1,6,8-11,14; column 2, line 39 - column 3, line 52; column 4, line 53 - column 8, line 13; figures 1,2 *	1-7,9	E 04 D D 06 N B 32 B
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 30-09-1987	Examiner BLASBAND I.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technical background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published later than the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	